

Work Order ID 80485

80485

Page 1

February-21-12 1:50:28 PM

Item ID: D3573-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Adapter

Start Date: 21/02/2012 Start Qty: 6.00 ¹⁶

6

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/12

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3573	Rev A

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 3.500" long								

P0 12/04/13 16 0

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA673 and Dwg D3573								

12 12.4.18 16 4

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

12 12.4.18 16 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Handwritten: Please use April 20
80485

Page 2

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NS1

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Stop

NS2

Item Name: Adapter

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Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140 Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320°F

11:20

M112338

(16) 7/6 12-4-19

16x 12/04/23

Dart Aerospace Ltd

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Page 3

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

16 x 6 12/16/12

170 Identify as per dwg & Stock Location: **QA**

0.00

170

Packaging

Memo

0.00

Packaging

160 12/16/12

180 QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/14/24

ME 12-04-24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

February-21-12 1:50:31 PM

Page 1

Work Order ID: 80485

80485

Parent Item: D3573-3

D3573-3

Parent Item Name: Adapter

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	6.1210	0.292	1.844211			

M6061T6B0 500X02 500

6061-T6 Bar .500 x 2.50

**

80

12/04/13

Location

Loc Qty

Loc Code

MAT001

6.121

→ 116623

6.121

4.91

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80485
Description: Adapter		Part Number:	D3573-3
Inspection Dwg: D3573	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3.314	/	REQ .02		
2.69	+/-0.030	2.692	/			
2.31	+/-0.030	2.310	/			
1.600	+/-0.005	1.660	/			
0.36	+/-0.030	.357	/			
1.19	+/-0.030	1.19	/			
2.38	+/-0.030	2.377	/			
1.420	+/-0.010	1.420	/			
0.48	+/-0.030	.480	/			
R0.63	+/-0.030	.63	/			
R0.13	+/-0.030	.13	/			
R0.02	+/-0.030	.02	/			
Ø0.209	+0.005/-0.001	.209	/			
Ø0.266	+0.006/-0.001	.267	/			
0.390	+0.010/-0.000	.393	/			
Ø0.675 x 0.190	+/-0.010	.679 x .189	/			
Ø0.500 x 0.310	+/-0.010	.500 x .310	/			

Measured by: <i>Re</i>	Audited by: <i>B.A</i>	Prototype Approval:	N/A
Date: <i>2.4.18</i>	Date: <i>12/04/18</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.04	New Issue	KJ/JLM	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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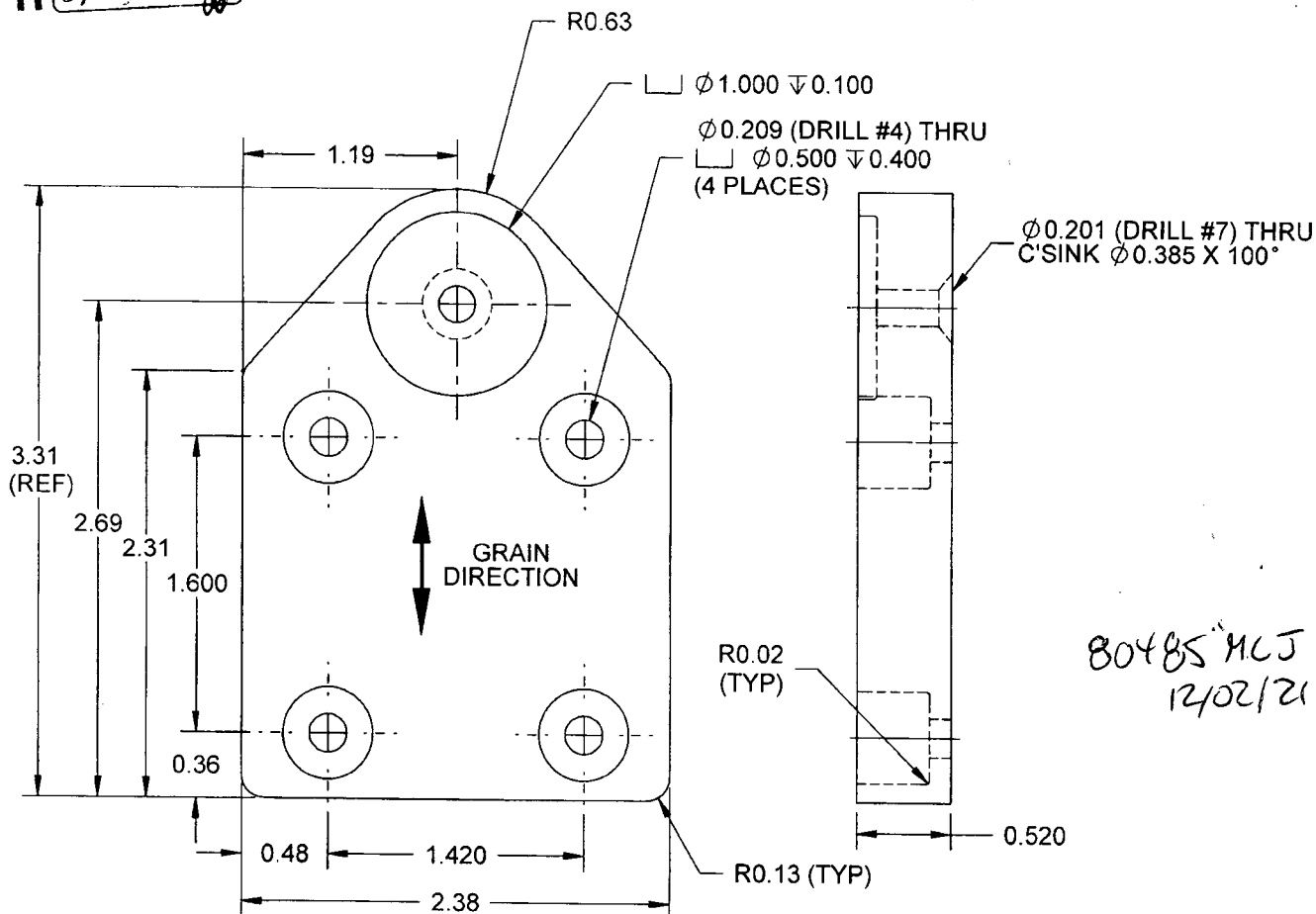
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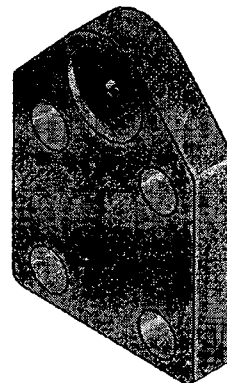
NOTE: Date & initial all entries

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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER SCALE 1:1		
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

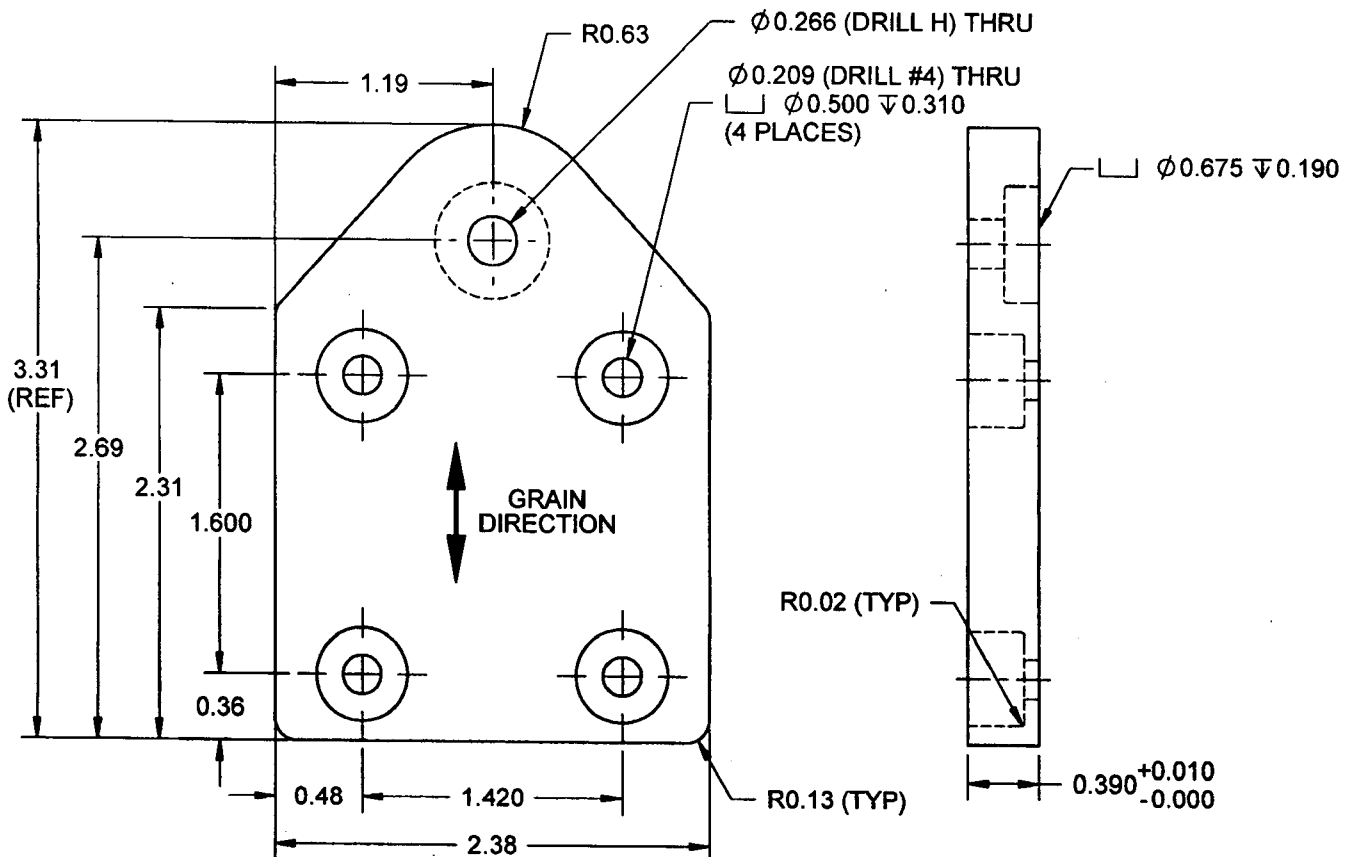
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573
DATE 07.02.19	TITLE ADAPTER	REV. A SHEET 2 OF 4 SCALE 1:1

RELEASED
07.04.02



D3573-3 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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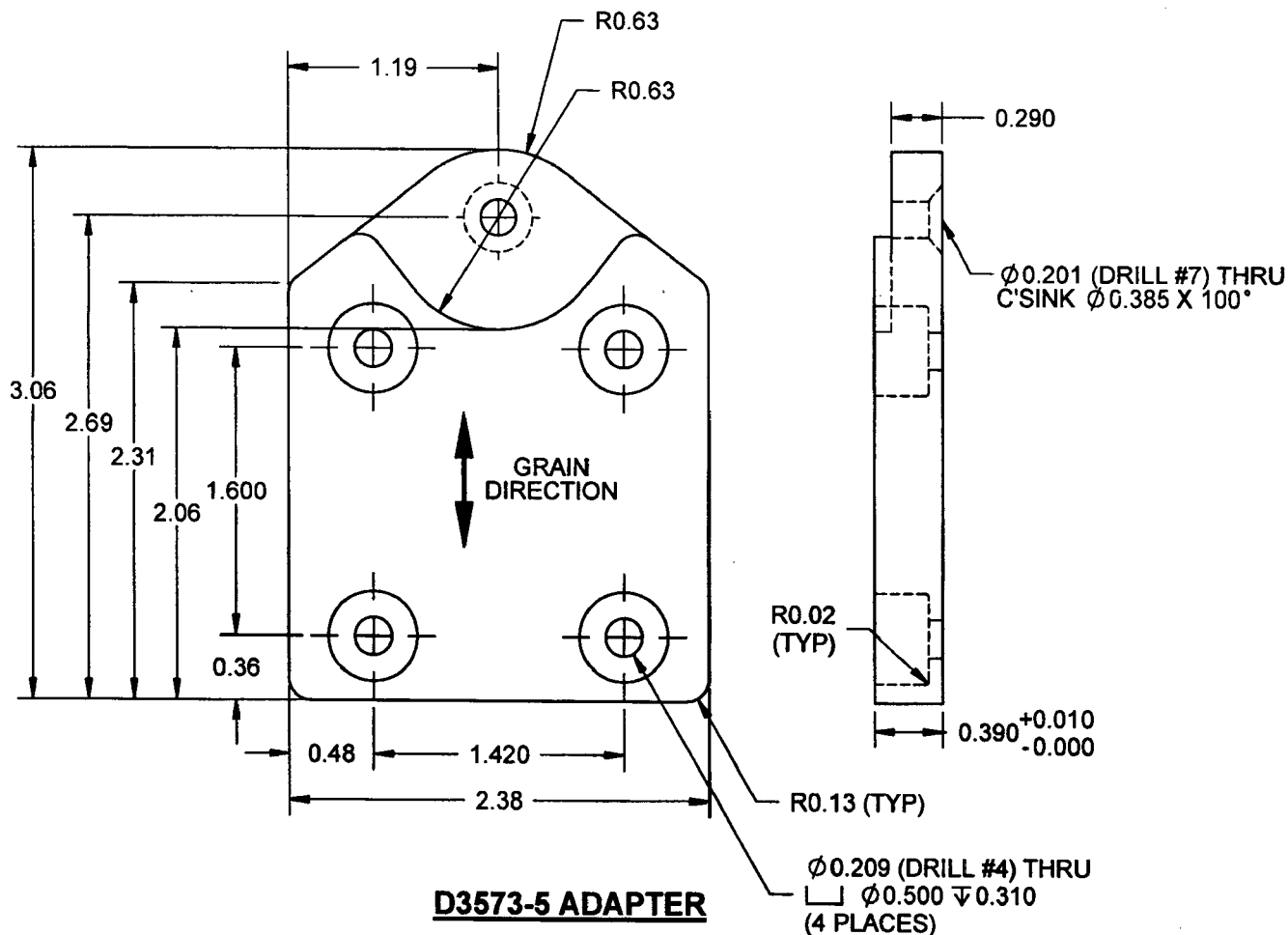
NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QAWCRWO RevE



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573
DATE 07.02.19	TITLE ADAPTER	REV. A SHEET 3 OF 4 SCALE 1:1

RELEASED
07.04.02



NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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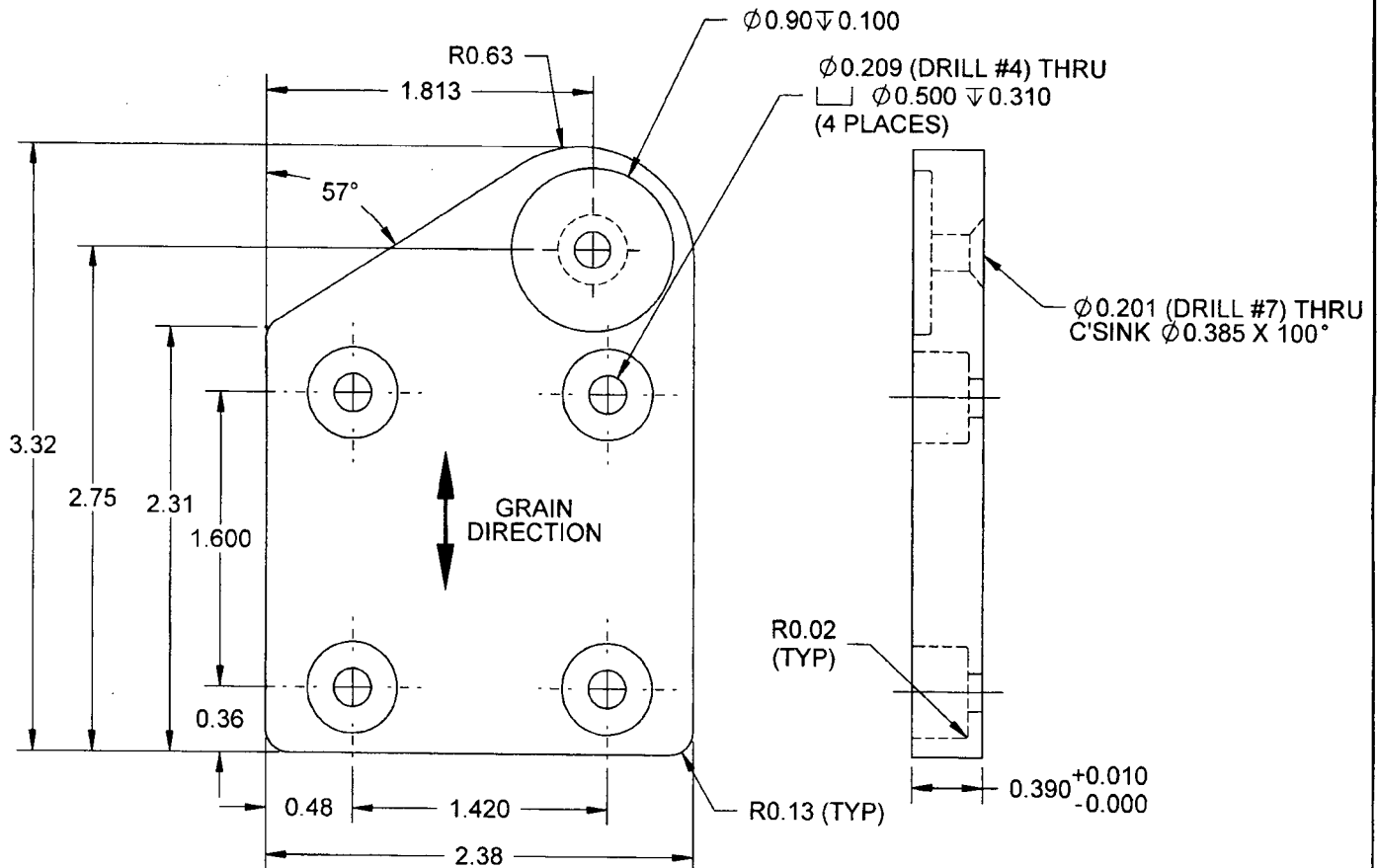
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DART

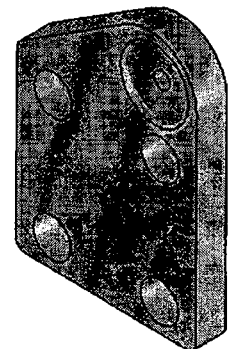
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A
DATE 07.02.19	TITLE ADAPTER		SHEET 4 OF 4 SCALE 1:1

RELEASED
07.04.02

D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
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- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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